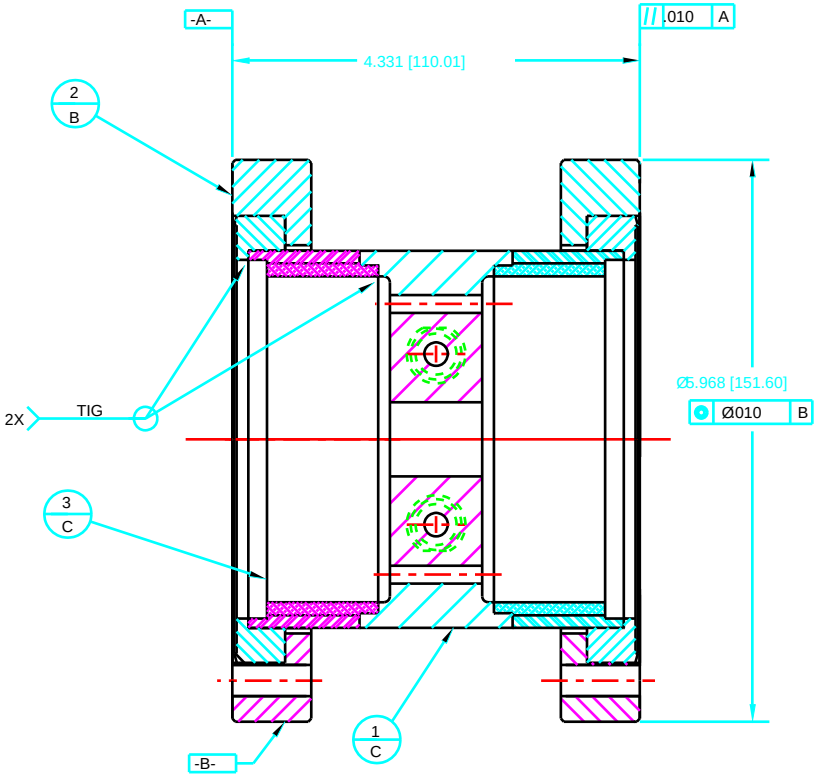
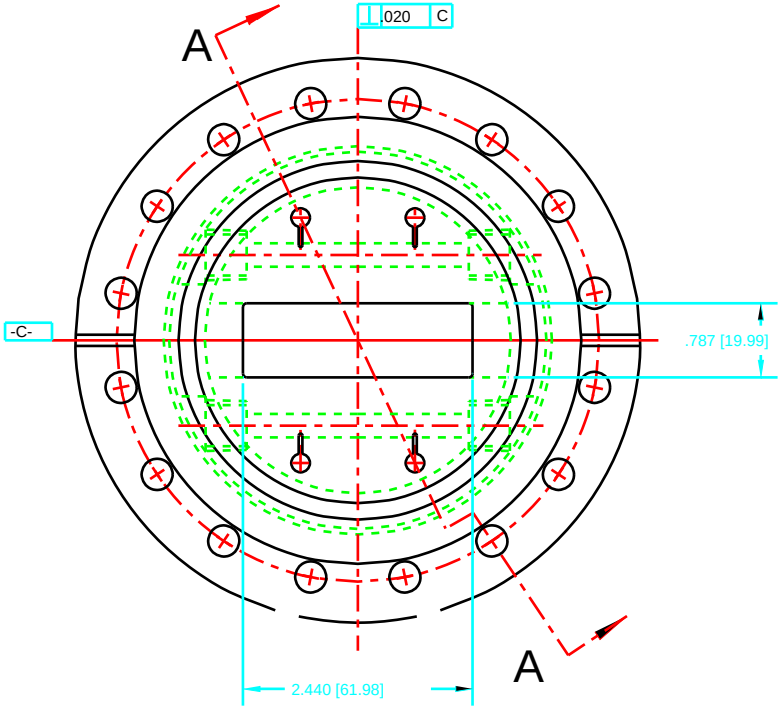
(℄	PLOT SCALE: 1=1	DWG. SCALE: 1	A08047





NOTES:

1. WELDMENT ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUN SENSITIVITY FOR HELIUM OF 2X 10 -10 STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:

   ALCATEL ASM-11OTCL
   VARIAN NCR 925 OR 936
   VEECO MS-9, MS-90 OR MS-18
   Du PONT CEC 24-120B

   CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.

   FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

2. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

3. DIMENSIONS IN [ ] ARE MILLIMETERS

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
3	P4102010101-210008	M1 COPPER TO METAL ADAPTER		2
2	P4102010103-250102	SOFT X-RAY ABSORBER END FLANGE		2
1	P4102010103-250101	SOFT X-RAY ABSORBER CENTER SECTION		1

PARTS LIST

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

REVISIONS

UNLESS OTHERWISE SPECIFIED:
ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS: .X ± .03 [.7620] / .XX ± .01 [0.25] / .XXX ± .005 [0.127]
ANGULAR ± .25
SURFACE ROUGHNESS 125

REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.

SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1

DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5

DO NOT SCALE DRAWING

LOG NUMBER: A08047

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ARGONNE NATIONAL LABORATORY

DRAWN BY: MUSCIA	DATE: 7/7/93	CHIEF DESIGN ENGINEER	DATE
CHECKED BY		GP LEADER	
DESIGNER: MUSCIA		PROJECT MGR.	
RESPONSIBLE ENGINEER		APPROVED/RELEASED	

TITLE:
ADVANCED PHOTON SOURCE
P1 1-ST PHOTON SHUTTER
SOFT X-RAY ABSORBER
WELDMENT ASSEMBLY

MATERIAL: SEE PARTS LIST

SCALE: 1:1
SHEET: 1 of 1

SIZE: C

DRAWING NUMBER: P4102010103-250100-00